

Date: Thursday, 6/21/2007 2:29:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FUEL PURGE CANISTER	
Job Number	: 33065B		Part Number	: D32623	
Estimate Number	: 10442		Drawing Number	: D3262 REV C	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/21/2007 S.O. No. : N/A		Drawing Revision	: C	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 7/15/2007	
Previous Run	: 32261B		Qty:	12 Um: Each	
Written By					
Checked & Approved By					
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
Comment: Qty.: 0.9668 f(s)/Unit Total : 11.6021 f(s) Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) Identify for D3262-3 Batch: 1104326		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: 6.000" x 0.500" x 5.400" long Bar Machine as per Folio FA457 and Dwg D3262 Identify for D3262-3 Deburr		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per dwg D3262		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 33065B

Part Number: D32623

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

3G 07-07-24 12

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/24 12x 50

7.0 QC21

FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

R 207/07/25

Job Completion



u 07.07.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33065B
Description: Cap	Part Number:	D3262-3
Inspection Dwg: D3262	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

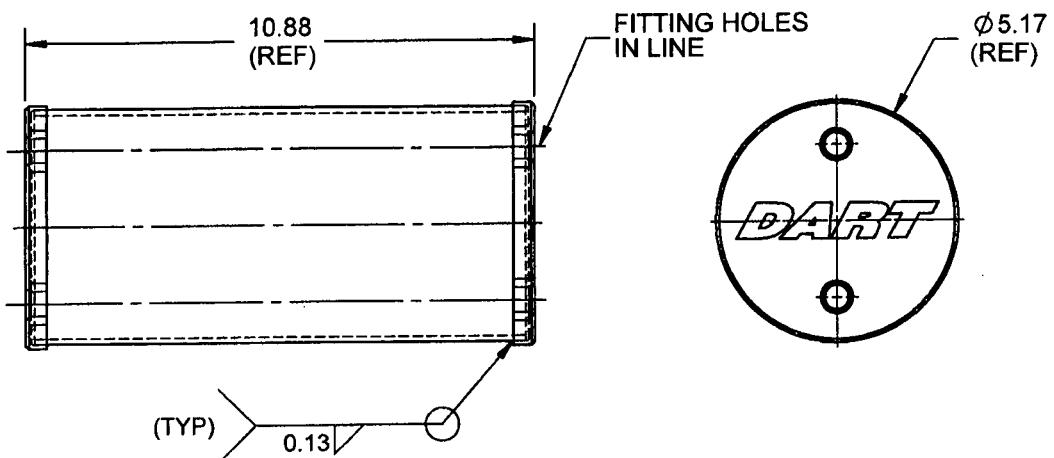
Measured by:	<u>Amber</u>	Audited by:	<u>J.L.</u>	Prototype Approval:	N/A
Date:	07/07/23	Date:	07/07/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>RF</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. D3262 REV. C SHEET 1 OF 2
DATE 06.08.31		TITLE SCALE FUEL PURGE CANISTER 1:4

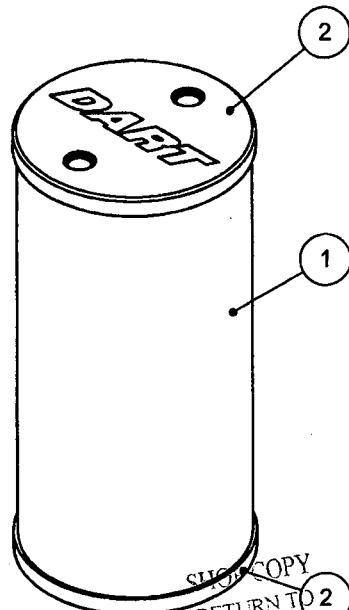
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06.09.19 *HA***D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3262-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO **A**
CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART
QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



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DART

DESIGN <i>RF</i>	DRAWN BY <i>BS</i>
CHECKED <i>PH</i>	APPROVED <i>MM</i>
DATE 06.08.31	

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

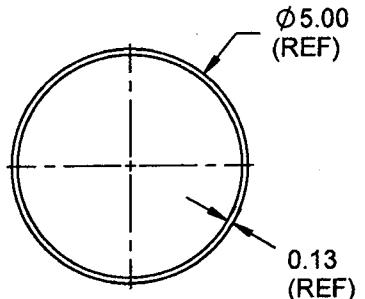
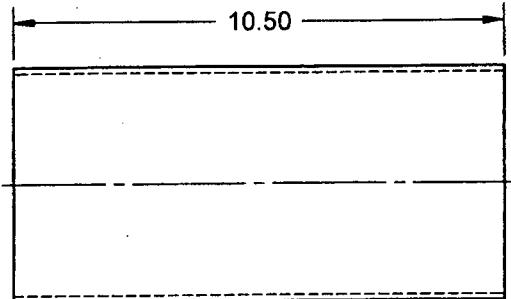
DRAWING NO.
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REV. C

SHEET 2 OF 2

SCALE

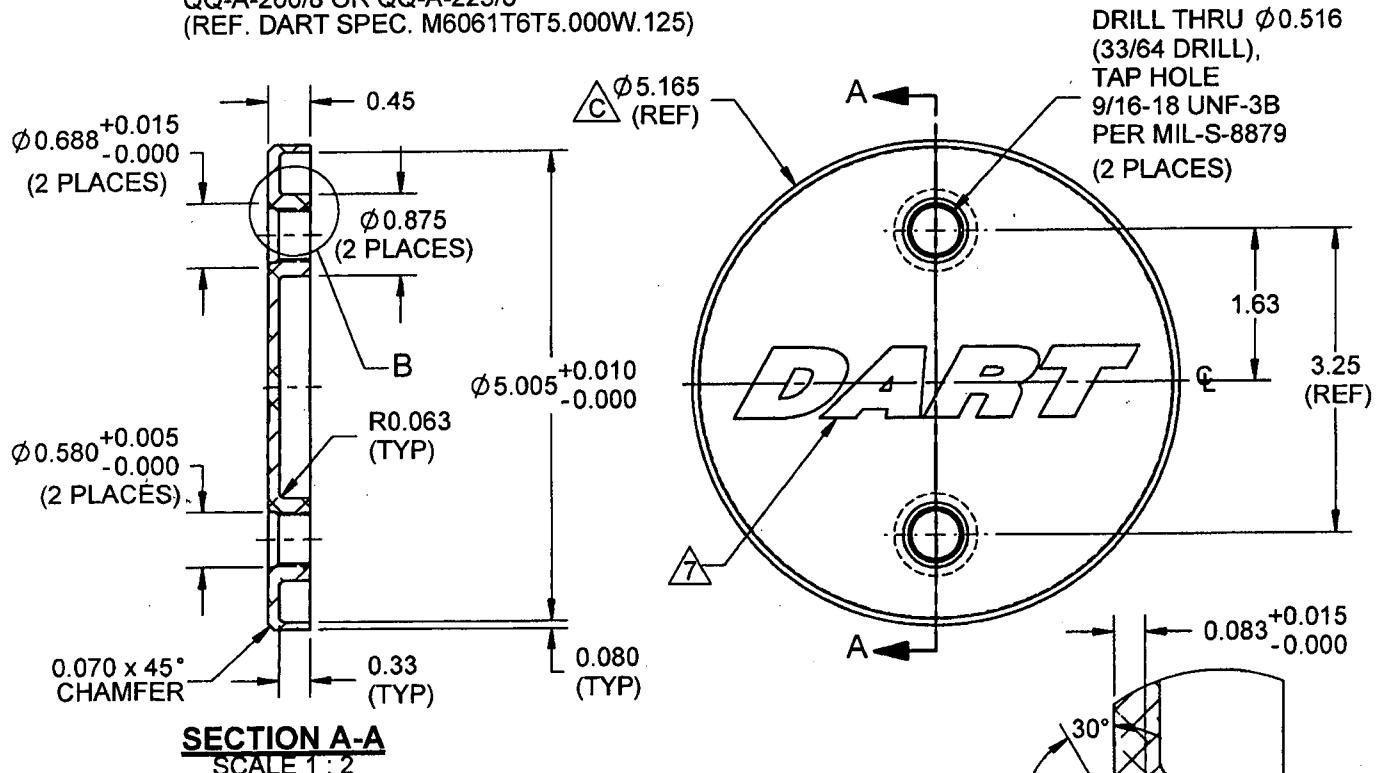
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RELEASED
06.09.04
MM

D3262-1 TUBE

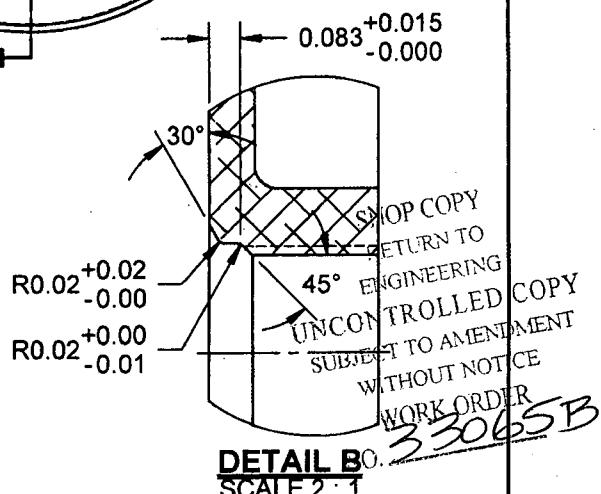
1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)

**SECTION A-A**
SCALE 1:2**D3262-3 CAP**

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



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